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RBT18561
Job Sheet 177961



Part No: RBT18561

Job Qty: 1 ea

Part Name: Bell 407 Field Maintenance



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/23/18

Job Tracking No:

Due Date: 11/5/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18561 Rev3 (TEO17-640) IPP Rev A 17.12.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/5/18	11/5/18	0.00	0.00	Start Up Small Fab-4		MLO
110	Small Fab	1 pcs	11/5/18	11/5/18	0.00	1.00	Small Fab-9		MLO
120	QC	1 pcs	11/5/18	11/5/18	0.00	0.00	QC4		MLO
130	Packaging	1 pcs	11/5/18	11/5/18	0.00	0.00	Packaging3		MLO
140	QC21-FG	1 Ea	11/5/18	11/5/18	0.00	0.00	QC21		MLO

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	10 Ea (2 ea)	90-Start up Operation	513449 SC84066
97524A032	Sealing Blind Rivet	20 Ea (4 ea)	90-Start up Operation	5113449
APP-1700-E	Case	5 Ea (1 ea)	90-Start up Operation	504384X1, 5044382X1, 5134922X1
CL-2-C	Lanyard Wire	5 ft (1 ea)	90-Start up Operation	5119833
RB H4713	Drain Hose	5 Ea (1 ea)	90-Start up Operation	5121381X3
RB H4749	Drain Hose	5 Ea (1 ea)	90-Start up Operation	5121381X3
RB23006782	Adapter, Torque Turbine Attach Lower Nut	5 Ea (1 ea)	90-Start up Operation	5139362X3 5079052X2
RB23006783	Adapter, Torque Turbine Attach Upper Nut	5 Ea (1 ea)	90-Start up Operation	5123127
RB23007615	Power Turbine Support Cleaning C-30 & C-47	5 Ea (1 ea)	90-Start up Operation	5136414
RB23007638	Fuel Injector Wrench	5 Ea (1 ea)	90-Start up Operation	5137332X2
RB41011	Dart Tooling Placard, Aluminum	5 Ea (1 ea)	90-Start up Operation	5126074X3
RBBP1425-101	Input Drive Shaft Tool (K-Flex)	5 Ea (1 ea)	90-Start up Operation	5135467
RBE2-10-1	Fuel System Cartridge Removal Tool	5 Ea (1 ea)	90-Start up Operation	5021040

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DART
AEROSPACE

Container No: S139647



Part: RBT18561

Job No: 177961

Serial No/Batch: S139647

Revision: 3

Inspector:

Exp Date:

Instructions:

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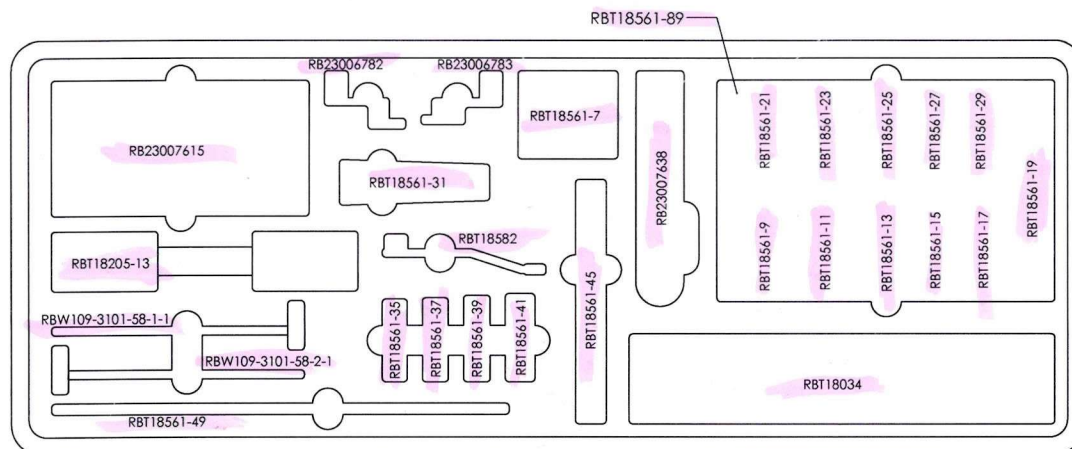
Date: 12/20/18

			Operation	
RBT112800	145	Power Take Off Seal Installation Tool	5 1 Ea (1 ea)	90-Start up
			Operation	5137108
RBT18025-13	144	Linear Scale (50 lbs)	5 1 Ea (1 ea)	90-Start up
			Operation	5131169
RBT18034	59	Main Rotor Pitch Link Protectors	5 1 Ea (1 ea)	90-Start up
			Operation	5046811
RBT18538	145	Pilot, Co-Pilot Seat Brace	5 1 Ea (1 ea)	90-Start up
			Operation	5129062 x2
RBT18560	145B	Engine Gearbox Seal Puller	5 1 Ea (1 ea)	90-Start up
			Operation	5138697
RBT18561-11		Needle Nozzle Grease Gun	10 2 Ea (2 ea)	90-Start up
			Operation	5036192 x9, 5077640 x1
RBT18561-13		Relay Base Removal	5 1 Ea (1 ea)	90-Start up
			Operation	5079669 x4
RBT18561-15		Extract Tool - Blue	10 2 Ea (2 ea)	90-Start up
			Operation	5079670
RBT18561-17		Extract Tool - Red	10 2 Ea (2 ea)	90-Start up
			Operation	5079671
RBT18561-19		Extract Tool - Green	10 2 Ea (2 ea)	90-Start up
			Operation	5043353
RBT18561-21		Extract Tool - Terminal Block	5 1 Ea (1 ea)	90-Start up
			Operation	5043354 x4
RBT18561-23		Extract Tool - Terminal Block	5 1 Ea (1 ea)	90-Start up
			Operation	5079673 x1
RBT18561-25		Relay Removal	5 1 Ea (1 ea)	90-Start up
			Operation	5079674
RBT18561-27		Posi-Drive Bits-Main Rotor Beanie	10 2 Ea (2 ea)	90-Start up
			Operation	5043356
RBT18561-29		Extraction Tool	10 2 Ea (2 ea)	90-Start up
			Operation	5097860 x8
RBT18561-31		10X Magnifier Glass	5 1 Ea (1 ea)	90-Start up
			Operation	5045223 x2
RBT18561-35		Offset 5/16 Torque Adapter	5 1 Ea (1 ea)	90-Start up
			Operation	5043357
RBT18561-37		Offset 3/8 Torque Adapter	5 1 Ea (1 ea)	90-Start up
			Operation	5044607 x4
RBT18561-39		Offset 1/2 Torque Adapter	5 1 Ea (1 ea)	90-Start up
			Operation	5082788 x1
RBT18561-41		Offset 9/16 Torque Adapter	5 1 Ea (1 ea)	90-Start up
			Operation	5133296
RBT18561-45		A/C Belt Tensioner	5 1 Ea (1 ea)	90-Start up
			Operation	5044608 x4
RBT18561-49		Tygon Hose	5 1 Ea (1 ea)	90-Start up
			Operation	5044609
RBT18561-7		Crowfoot	5 1 Ea (1 ea)	90-Start up
			Operation	5136892
RBT18561-75		Bottom Foam (3 x 13-3/4 x 36, Ethafoam 220, Black)	5 1 Ea (1 ea)	90-Start up
			Operation	5136893
RBT18561-77		Top Shelf Foam (2-1/16 x 13-3/4 x 35-1/2, Ethafoam 220, Black)	5 1 Ea (1 ea)	90-Start up
			Operation	5048059
RBT18561-79		Stiffener (0.236 x 13-3/4 x 35-1/2, Coroplast, Black)	5 1 Ea (1 ea)	90-Start up
			Operation	5078467
RBT18561-81		Contents & Location Placard	5 1 pcs (1 ea)	90-Start up
			Operation	5044390 x1, 5044389 x1, 5134924 x1,
RBT18561-89		Storage Box	5 1 Ea (1 ea)	90-Start up
			Operation	5134918 x1, 5044391 x1
RBT18561-9		Insert Tool-Whelen Connectors	5 1 Ea (1 ea)	90-Start up
			Operation	5044398 x1, 5044395 x1, 5134923 x1,
RBT18582		Tail Rotor Gear Box Torque Adapter	5 1 Ea (1 ea)	90-Start up
			Operation	5134917 x1, 5044397 x1
RBT400213		407 Trim Tab Bender	5 1 Ea (1 ea)	90-Start up
			Operation	5044402 x1, 5044401 x1, 5134921 x1,
RBT400214		Trim Tab Bending Gauge	5 1 Ea (1 ea)	90-Start up
			Operation	5134915 x1, 5044404 x1
RBT400325		Tail Boom Nut Socket (407)	5 4 Ea (1 ea)	90-Start up
			Operation	5131797
RBW109-3101-58-1-1 Hammer, Steel			5 1 Ea (1 ea)	90-Start up
			Operation	5077648
RBW109-3101-58-2-1 Hammer, Aluminum			5 1 Ea (1 ea)	90-Start up
			Operation	5046781
			Operation	5123783
			Operation	5135714
			Operation	5137450 x2
			Operation	5136262 x3
			Operation	5128099
			Operation	5135372
			Operation	5135402

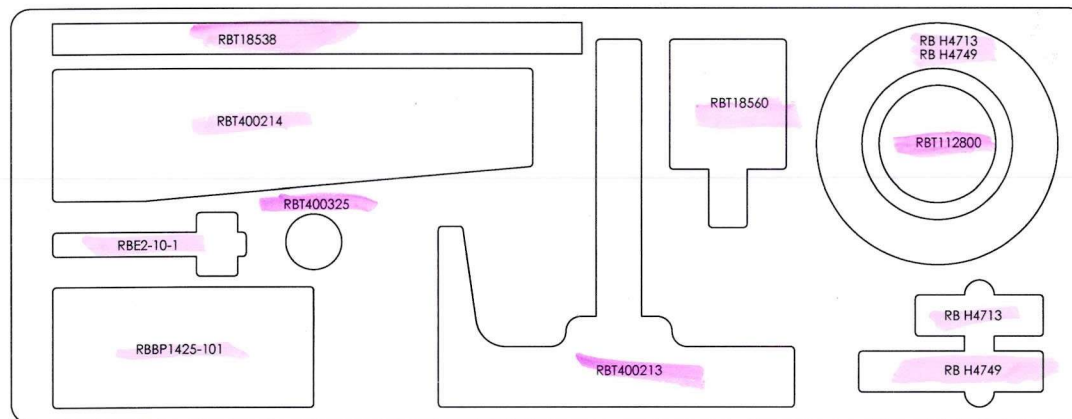
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	2	799	0
	97524A032	4	991	0
	APP-1700-E	1	19	0
	CL-2-C	1	232	0
	RB H4713	1	0	0
	RB H4749	1	6	0
	RB23006782	1	0	0
	RB23006783	1	1	0
	RB23007615	1	0	0
	RB23007638	1	0	0
	RB41011	1	770	0
	RBBP1425-101	1	2	0
	RBE2-10-1	1	4	0
	RBT112800	1	4	0
	RBT18025-13	1	18	0
	RBT18034	1	6	0
	RBT18538	1	4	0
	RBT18560	1	4	0
	RBT18561-11	2	18	0
	RBT18561-13	1	9	0
	RBT18561-15	2	20	0
	RBT18561-17	2	20	0
	RBT18561-19	2	20	0
	RBT18561-21	1	10	0
	RBT18561-23	1	10	0
	RBT18561-25	1	10	0
	RBT18561-27	2	16	0
	RBT18561-29	1	9	0
	RBT18561-31	1	7	0
	RBT18561-35	1	8	0
	RBT18561-37	1	10	0
	RBT18561-39	1	10	0
	RBT18561-41	1	10	0
	RBT18561-45	1	10	0
	RBT18561-49	1	22	0
	RBT18561-7	1	10	0
	RBT18561-75	1	8	0
	RBT18561-77	1	8	0
	RBT18561-79	1	8	0
	RBT18561-81	1	5	0
	RBT18561-89	1	10	0
	RBT18561-9	1	11	0
	RBT18582	1	13	0
	RBT400213	1	0	0
	RBT400214	1	0	0
	RBT400325	1	4	0
	RBW109-3101-58-1-1	1	2	0
	RBW109-3101-58-2-1	1	1	0
Part Specifications				
Specifications could not be found.				

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TOP SHELF



BOTTOM CUSHION

TOOL LAYOUT

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CORRECTED -11 B/O P/N FROM 6Y900 TO GY900.	1/14/2013	RJC	SE
1		CHD -75 TOOL LAYOUT, ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUTS FOR INDIVIDUAL QUILTS (RB H4713, RB H4749). MOVED RBT112800, CHD SQUEEZE BOTTLE DEPTH FROM 2.65 TO 2.35 & 3.43 TO 3.08.	1/14/2013	RJC	SE
1A		-7 CHD BOM INFO WAS 1/2 DRIVE IS 3/8 DRIVE, -13 NUMBER WAS M6106/32-002 IS M6106/32-001.	3/8/2013	BIM	SE
1B		CORRECTED T/N ON BOTTOM TOOL LAYOUT WAS RBT400235 IS RBT400325.	1/21/2014	RJC	RJC
2	16-0139	-75 & -77 CHD MATERIAL & SUPPLIER WAS Y20 BLACK, I.R. SPECIALTY IS ETHAFOAM 220, BLACK. CASE SOLUTIONS: -75 DELETED RBT18561-39 & RBT18561-61 FROM KIT AND CHD TOOL LAYOUT, CHD DIM WAS 4X R.64 IS 3X .45 X 45°. -77 ADDED CUTOUTS FOR RBW109-3101-58-1, RBW109-3101-58-2 AND RBT18034. DELETED -33 AND ADDED -34 AND CHD CUTOUT FOR NEW SCALE. -79 CHD DIM WAS 28.44 IS 35.50, ADDED BLACK TO COROPLAST MATERIAL CUTOUT, -81 UPDATED WITH NEW S AND DELETED TOOLS, CHD PAPER WAS WHITE IS RED.	9/2/2016	RJC	JAG
3	16-0251	CORRECTED DWG, TITLE WAS FIELD TOOL KIT IS 407 FIELD MAINTENANCE KIT, CORRECTED T/N WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 IS RBW109-3101-58-2-1, -31 ADDED B/O INFO (MCMaster-CARR #8485113). -75, -77, -79, -81 CHD DWG, TO SHEET METAL TOLERANCE. -75, -77 ADDED DIM 4X R.64, -81 CORRECTED T/N WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 IS RBW109-3101-58-2-1.	12/5/2016	RJC	SM

TEO ATTACHED

DART AEROSPACE	
TITLE 407 FIELD MAINTENANCE KIT	
DWG NO. RBT18561	REV 3
MATL HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125/✓ 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DUERFELDT	BELL 407
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:4	DATE 12/28/2011 SHEET 1 OF 6